

Work Order ID 65475

January 18, 2011 10:31:06 AM



Page 1

Item ID: D3479-041

Accept



Setup Start



Revision ID:

Item Name: Inlet Adapter

Stop



Start Date: 1/18/11 Start Qty: 2.00



Cust Item ID:

Required Date: 1/31/11 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: CL

Date: 11/01/18

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3479

Rev B

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Assemble as per Dwg D3479

2-Spot Weld as per Dwg D3479 and Dart QSI 018

⇒ M-L 11/01/25

(2X)

110

QC11- Inspect spot weld per QSI004

0.00



QC

Memo

0.00

Quality Control

SB 11/01/25

(2)

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

SB 11/01/25

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65475

January 18, 2011 10:31:06 AM



Page 2

Item ID: D3479-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Inlet Adapter

Start Date: 1/18/11 Start Qty: 2.00



Cust Item ID:

Required Date: 1/31/11 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: 060

0.00



Packaging

Memo

0.00

Packaging

11/01/25 (2)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/01/26MF
11-01-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 18, 2011 10:31:05 AM

Page 1

Work Order ID: 65475

Parent Item: D3479-041

Parent Item Name: Inlet Adapter



Start Date: 1/18/11

Required Date: 1/31/11

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev: A New Issue 06-02-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3479-1 Tube		Manufactured	No			100	Each	2.0000	1	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST063				2					
					46273			2					
D3479-3 Tab, 99 degrees		Manufactured	No			100	Each	5.0000	1	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST063				5					
					35162			4					
					46274			1					
D3479-5 Tab, 81 degrees		Manufactured	No			100	Each	4.0000	1	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST064				4					
					35163			4					
D3479-7 Flange Plate		Manufactured	No			100	Each	4.0000	1	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST064				4					
					34090			4					



SB 11/01/20



SB 11/01/20



SB 11/01/20



SB 11/01/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

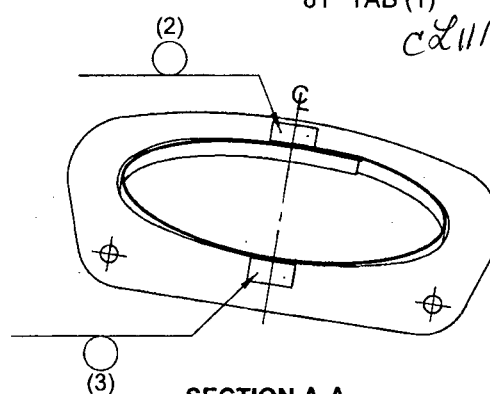
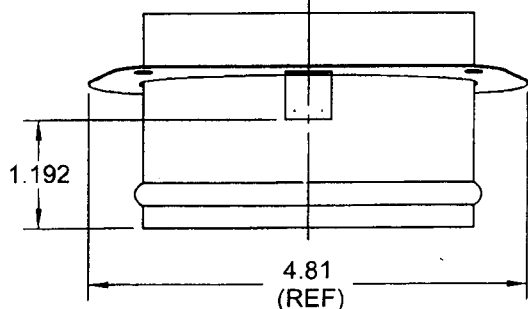
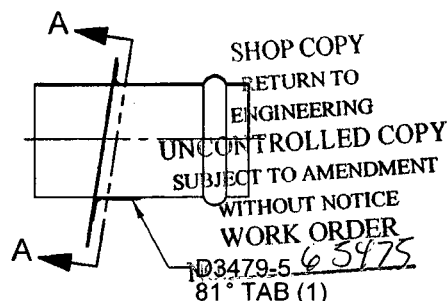
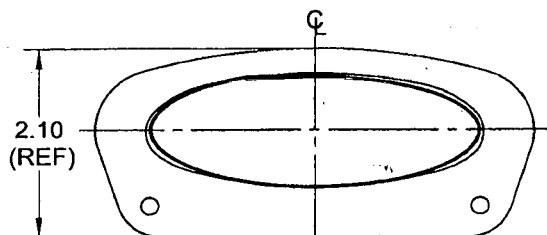
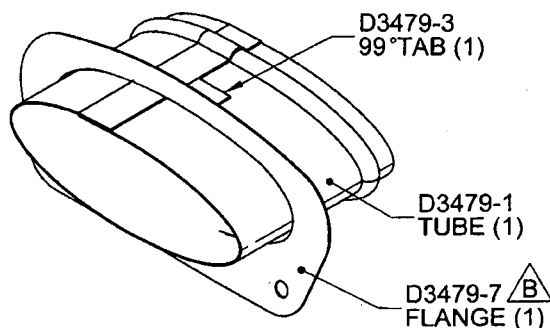
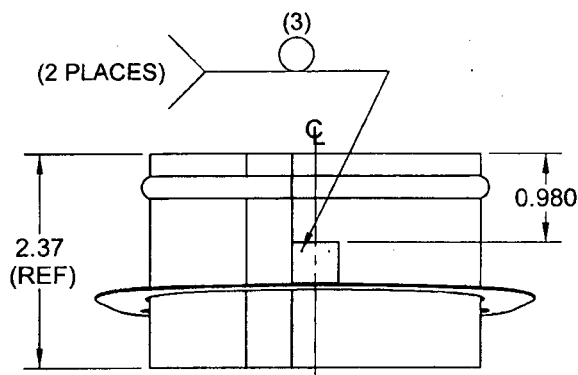
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3479	REV. B SHEET 1 OF 4
DATE 08.12.19		TITLE INLET ADAPTER	SCALE 1:2
A	06.01.19	NEW ISSUE	
B	08.12.19	CORRECT TYPO ON SHT1; ADD TOL ON SHT2; MATL SPEC WAS MIL-S-5019	

RELEASED
01/01/30



D3479-041 INLET ADAPTER

NOTES:

- 1) SPOT WELD PER DART QSI 018
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3479-041 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

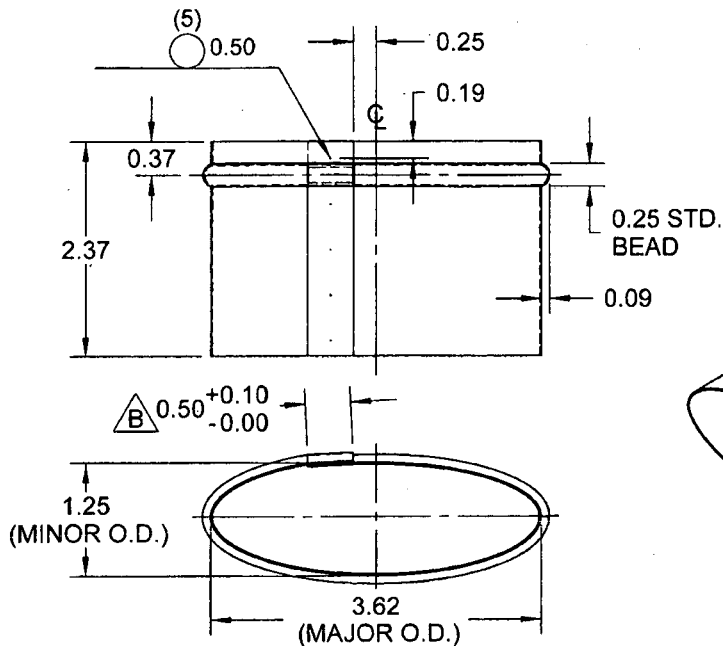
QTY -041	P/N	DESCRIPTION
X	D3479-041	INLET ADAPTER
1	D3479-1	TUBE
1	D3479-3	99 DEGREE TAB
1	D3479-5	81 DEGREE TAB
1	D3479-7	FLANGE

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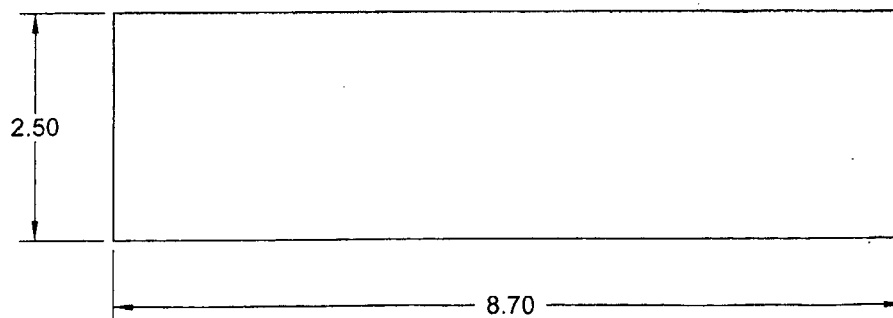
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DATE 08.12.19		TITLE INLET ADAPTER	SCALE 1:2

RELEASED
07/01/2019**D3479-1 TUBE**

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WORK ORDER
NO. *65475*

**D3479-1F FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH $\triangle B$
OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) SPOT WELD PER DART QSI 018
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

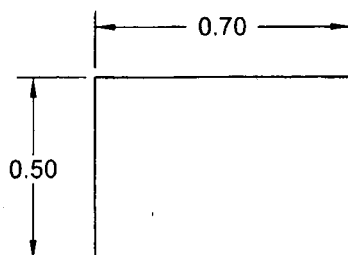
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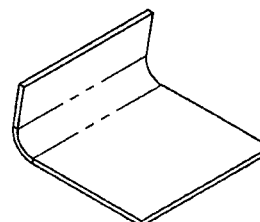
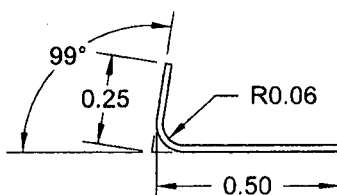
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CHECKED PH	APPROVED [Signature]	DRAWING NO. D3479	REV. B SHEET 3 OF 4
DATE 08.12.19		TITLE ADAPTER INLET	SCALE 2:1

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09/01/30 MP

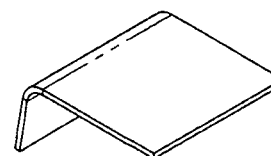
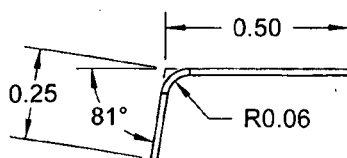


D3479-3F FLAT PATTERN

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH $\triangle B$
OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)



D3479-3 99 DEGREE TAB (MAKE FROM D3479-3F FLAT PATTERN)



D3479-5 81 DEGREE TAB (MAKE FROM D3479-3F FLAT PATTERN)

NOTES:

- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

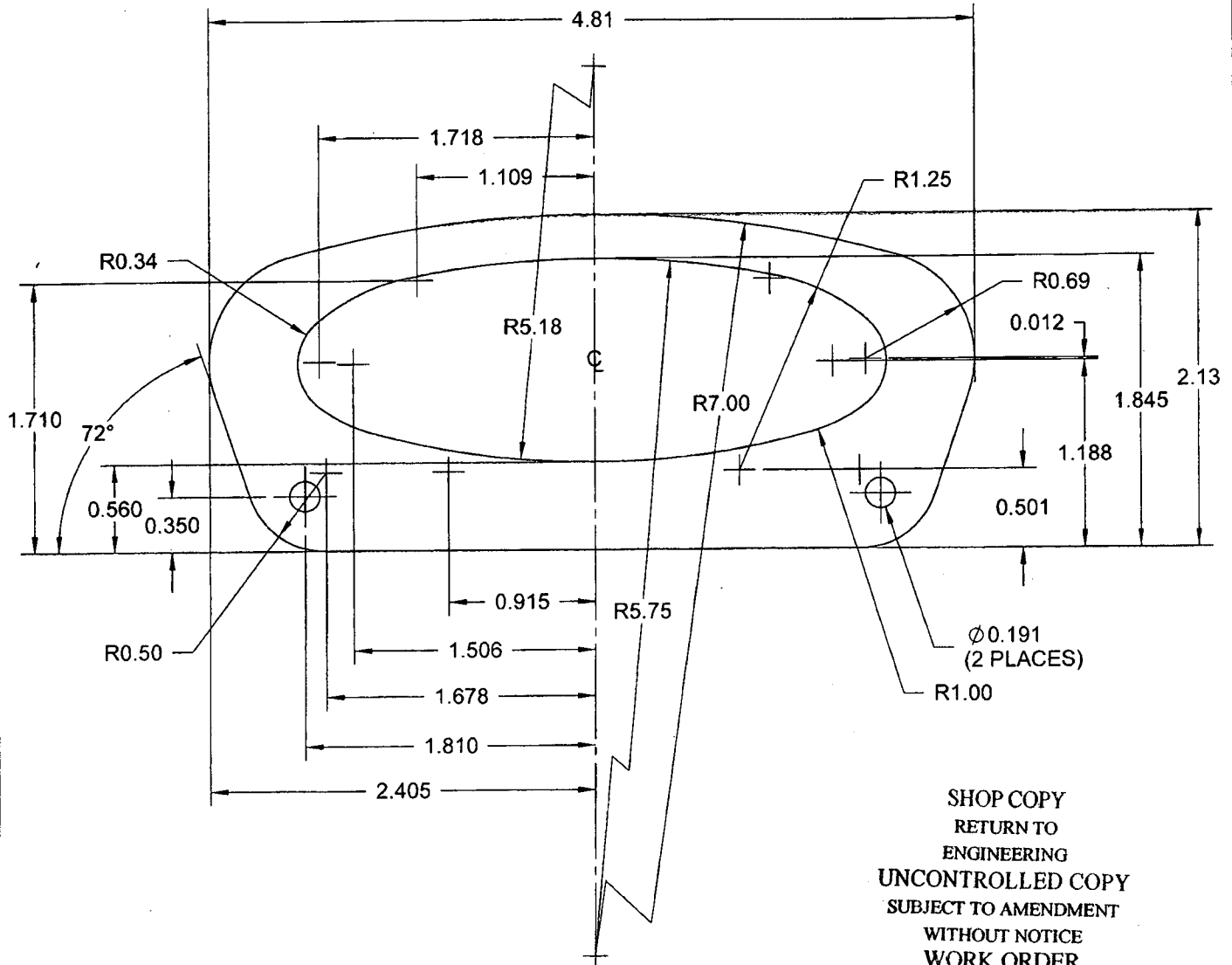
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DART

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CHECKED <i>RA</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3479	REV. B SHEET 4 OF 4
DATE 08.12.19		TITLE ADAPTER INLET	SCALE 1:1

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27/6/30 MB

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D3479-7 FLANGE PLATE**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH $\triangle B$
OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) PART IS SYMMETRICAL ABOUT CENTERLINE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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SPOT WELD TEST RECORD

AMS-W-6858A

CLASS 'C'

TEST NO#: 86

EMPLOYEE: Marc Gregory

PART NUMBER: D3479-041

JOB NUMBER: 65475

MATERIAL TYPE: 304 L

MATERIAL THICKNESS: .018

GROUP SPECIFICATION



Group 1: Aluminum & magnesium



Group 2: Iron; nickel; cobalt



Group 3: Titanium SS

TEST RESULTS

	PASS	FAIL
VISUAL:	[<input checked="" type="checkbox"/>]	[<input type="checkbox"/>]
PENETRATION:	[<input checked="" type="checkbox"/>]	[<input type="checkbox"/>]
PULL STRENGTH:	[<input checked="" type="checkbox"/>]	[<input type="checkbox"/>]

PSI Reading: _____

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 11/01/25

QUALIFIER: SB